

Work Order ID 58198

Wednesday, April 28, 2010 12:45:57 PM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 4/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 10-4-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3391	Rev H
-------	-------

100



0.00

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

If D412-742-043 is a W/O on its own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004
N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 4/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

110

Operation
Description

HandFinishing

Set Up/
Run Hours

0.00

Draw
Number

o

Draw
Rev.

o

Plan
Code

o

Accept
Qty

o

Reject
Qty

o

Reject
Number

o

Insp.
Stamp

HandFinish

Hand Finishing

Memo

0.00

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M 112-429Expiry date: 10/08

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R Sikaflex-241/-291 M 112-429Expiry date: 10/08

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/R LPS Procyon 104251

BL 104-28 D

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S 10/04/79

130



Packaging

Packaging

Packaging

Memo

0.00

0.00

7P 58226

10-5-3



140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/05 JF

U 1025.04

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Picklist Print

Page 1

Wednesday, April 28, 2010 12:45:56 PM

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Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 4/28/2010

Required Date: 5/21/2010

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev:C 07-05-28 As per Rev F
IPP Rev:D 07-12-04 ECN 1072

KJ/JLM

EC

JLM

DD verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

AN3C4A



Purchased

No

110

Each

1,405.000 24.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST350 1141830

1405

24. BR 10-4-29

114103

501

114108

300

114330

104

114416

500

AN3C6A



Purchased

No

110

Each

639.0000 12.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST351 111982 ✓

639

111982 ✓

639

AN3C7A



Purchased

No

110

Each

285.0000 8.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST351 113149 ✓

285

113149 ✓

185

114382

100

12. BR 10-4-29

8. BR 10-4-29.

W/O:		WORK ORDER CHANGES					
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IPP Rev:C 07-05-28 As per Rev F
IPP Rev:D 07-12-04 ECN 1072

KJ/JLM□

EC

JLM

DD verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

AN960C10L



washer

D3391-021

Purchased

No

110

Each

0.0000

44.0000

NAS1149C0332R

114341



44

BL 10-4-29

Manufactured

No

110

Each

0.0000

1.0000



Manufactured

No

110

Each

1.0000

1.0000



1 BL 10-4-28.

WarehouseLocation

Main Warehouse

FP 56490

40522

Loc QtyLoc Code

1

BL 10-4-28.

D3391-025



Manufactured

No

110

Each

1.0000

1.0000

WarehouseLocation

Main Warehouse

FP 56501

48122

Loc QtyLoc Code

1

BL 10-4-28.

Aft Tube Assembly



W/O:		WORK ORDER CHANGES					
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IPP Rev:C 07-05-28 As per Rev F
IPP Rev:D 07-12-04 ECN 1072

KJ/JLM

EC

JLM

DD verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-1



Manufactured No

110

Each

14.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

OFFSHORE

FG

2

33798

2

Main Warehouse

FP

12

51676 ✓

12

D3564-3



Manufactured No

110

Each

15.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

OFFSHORE

FG

2

33764

2

Main Warehouse

FP

2

50113 ✓

2

Main Warehouse

FP19

11

55489

11

*BL 10-4-29**BL 10-4-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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IPP Rev A□05.10.13□New Issue□
IPP Rev B□06.02.13□ECN 773 dwg @ rev.D
IPP Rev:C 07-05-28 As per Rev F
IPP Rev:D 07-12-04 ECN 1072

KJ/JLM□

EC

JLM

DD verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

110

Each

12.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

10

57525 ✓

10

1 BK 10-4-29.

D3566-1

Manufactured No

110

Each

39.0000

2.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP015

39

57257 ✓

3

57715

36

2 BK 10-4-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

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IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev:C 07-05-28 As per Rev F
IPP Rev:D 07-12-04 ECN 1072

KJ/JLM

EC

JLM

DD verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured No

110

Each

32.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP015	32	
56829 ✓	1	
57526	11	
57682	20	

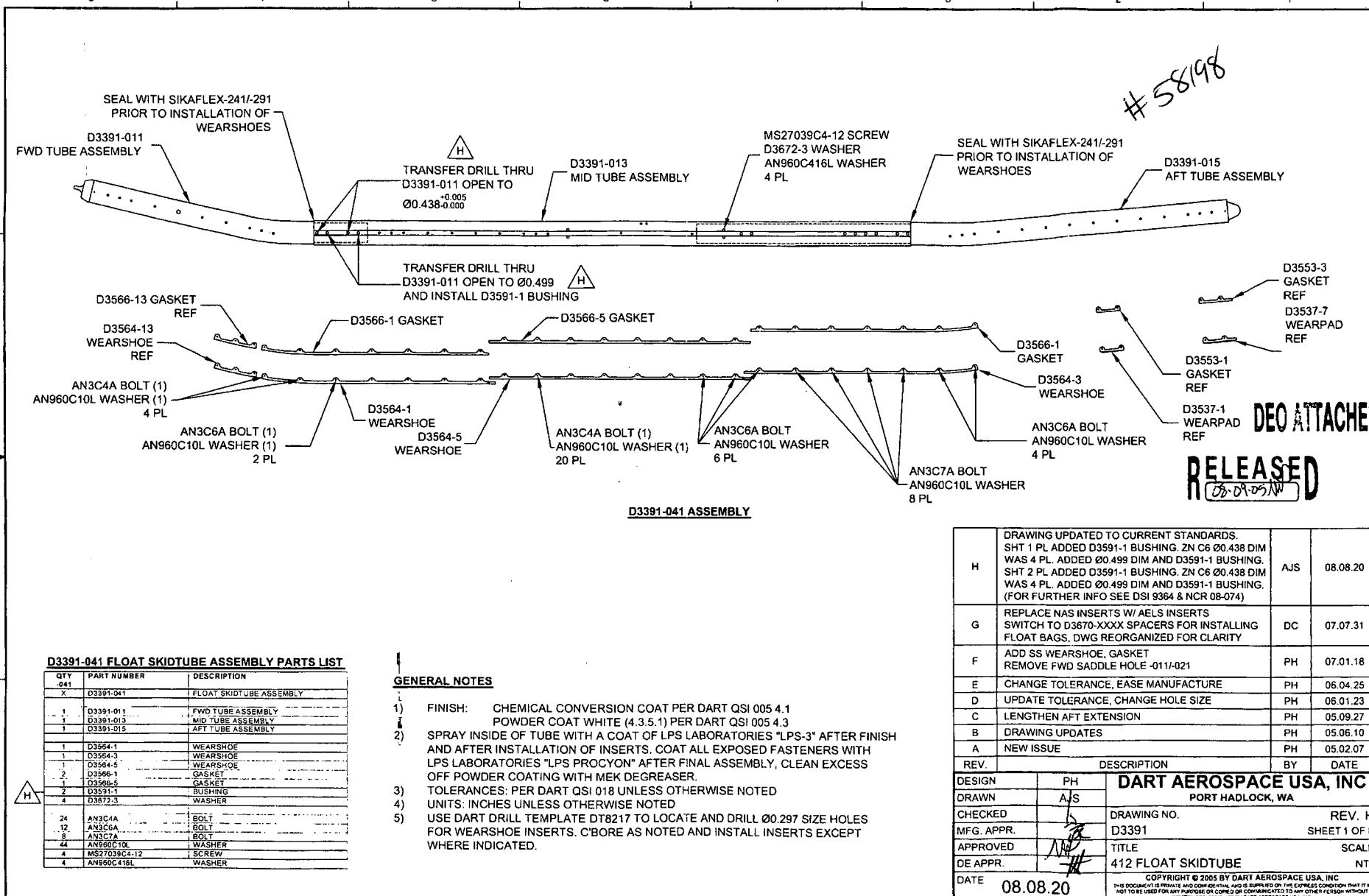
1 BK 10-4-29.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

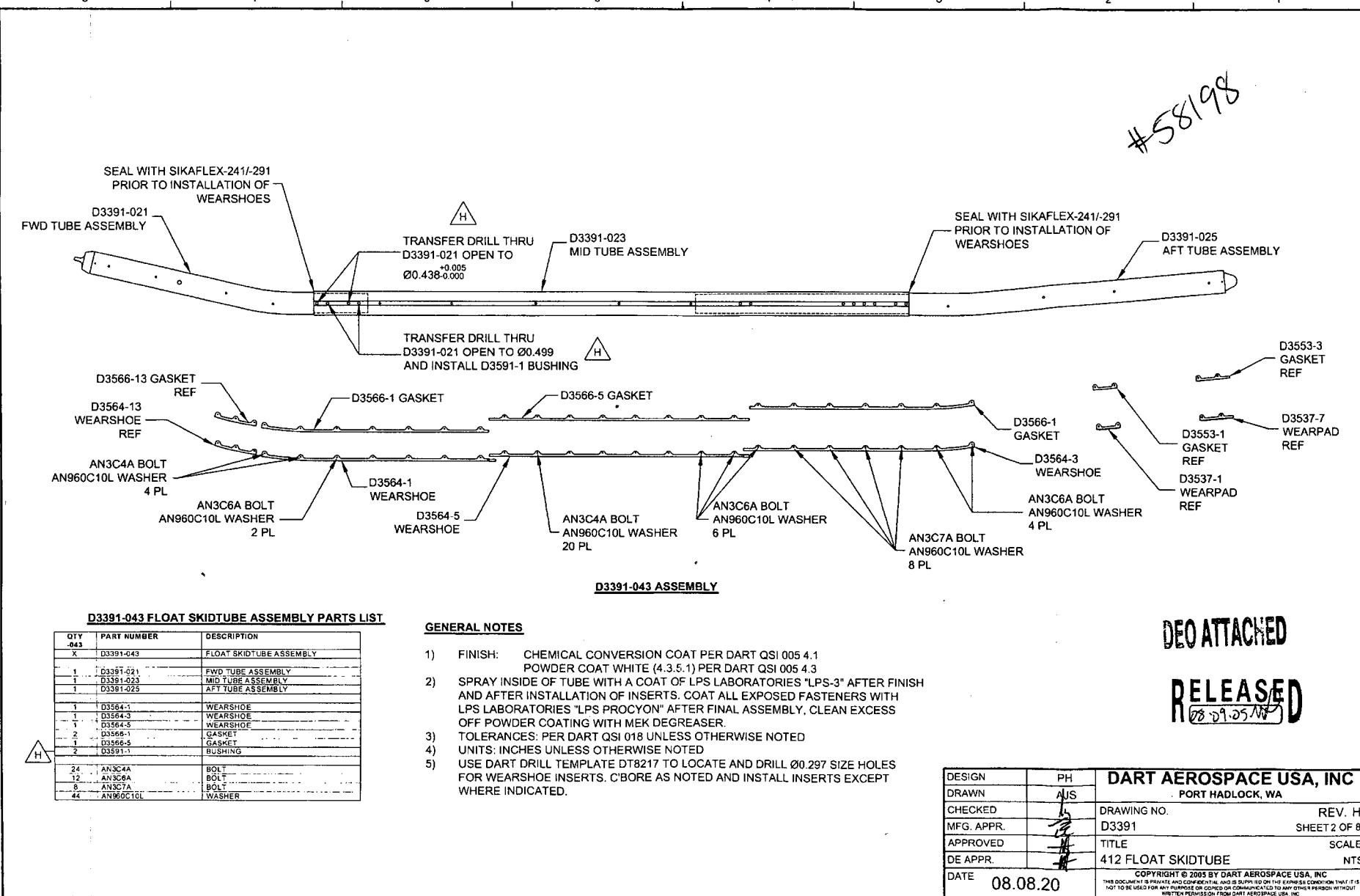


W/O:		WORK ORDER CHANGES					
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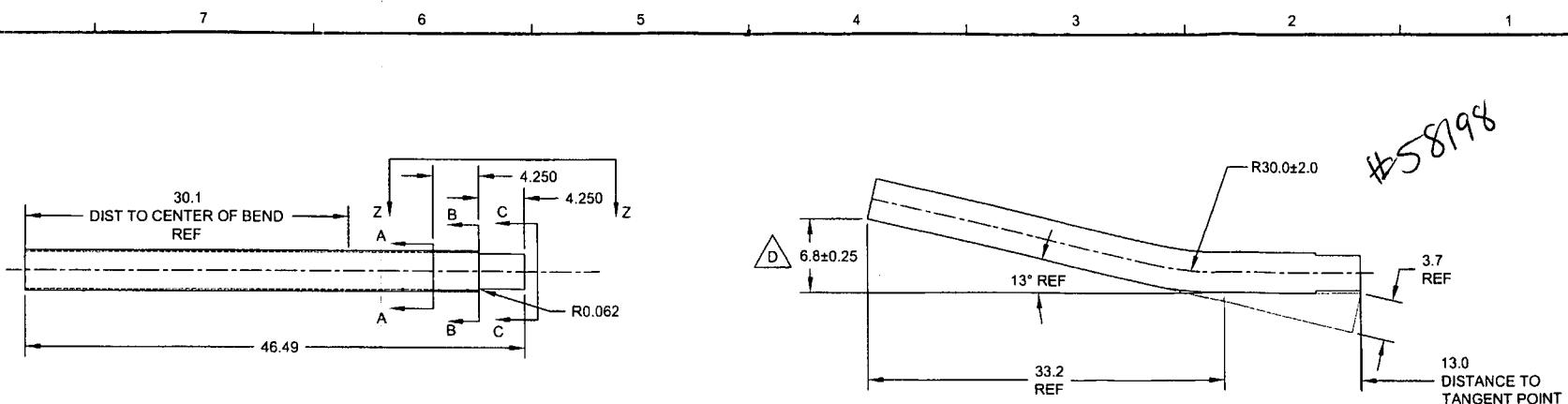


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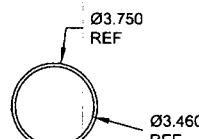
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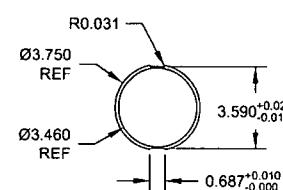


D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

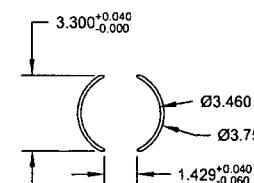
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



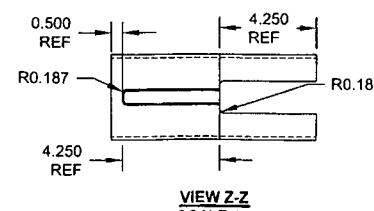
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	AJS	PORT HADLOCK, WA
CHECKED		DRAWING NO. D3391
MFG. APPR.	60	REV. H
APPROVED	N/A	SHEET 3 OF 8
DE APPR.	N/A	TITLE
DATE	08.08.20	SCALE NTS

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DETACHED
RELEASED
08.08.20

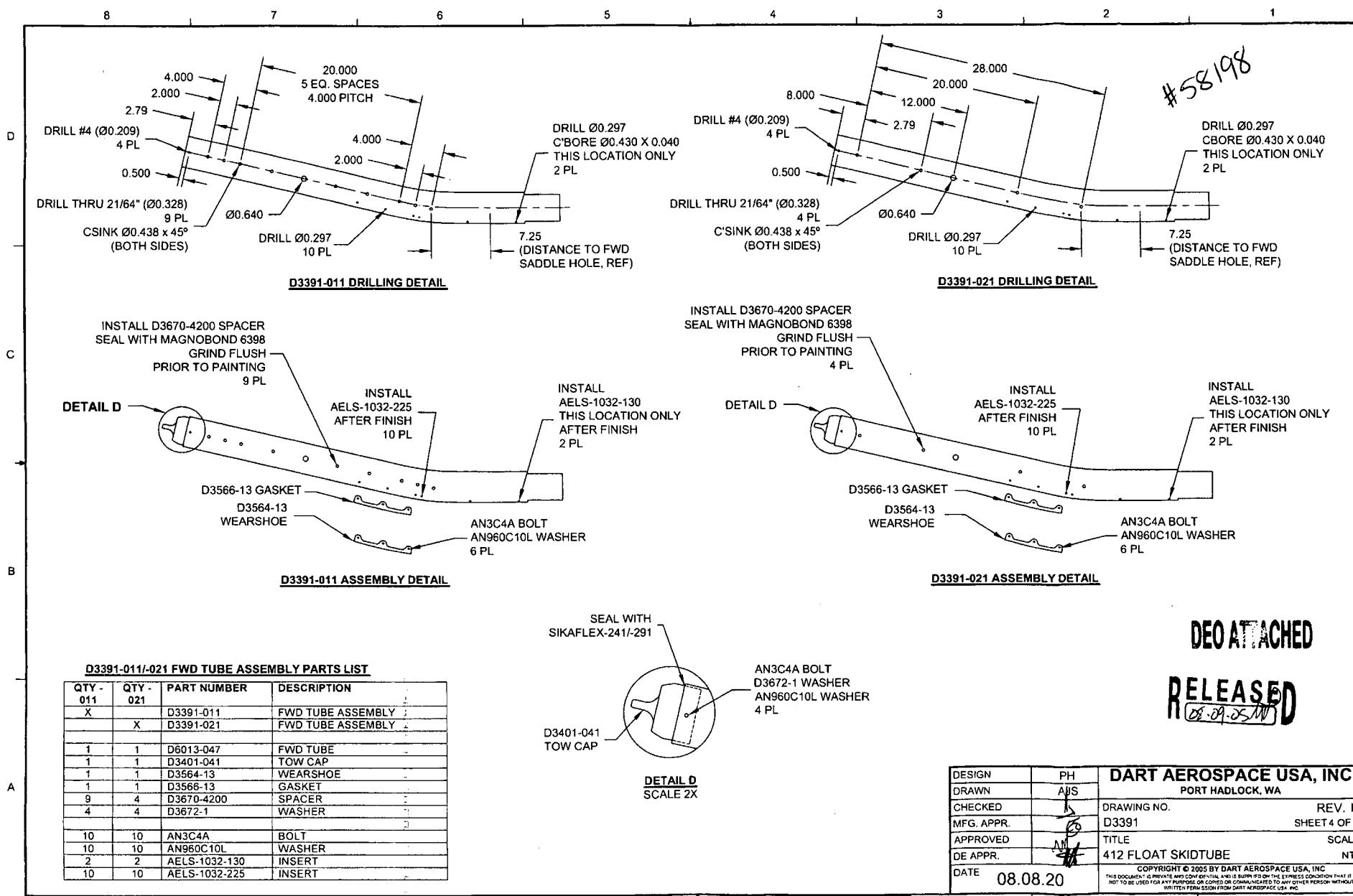
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#58198

DET ATTACHED

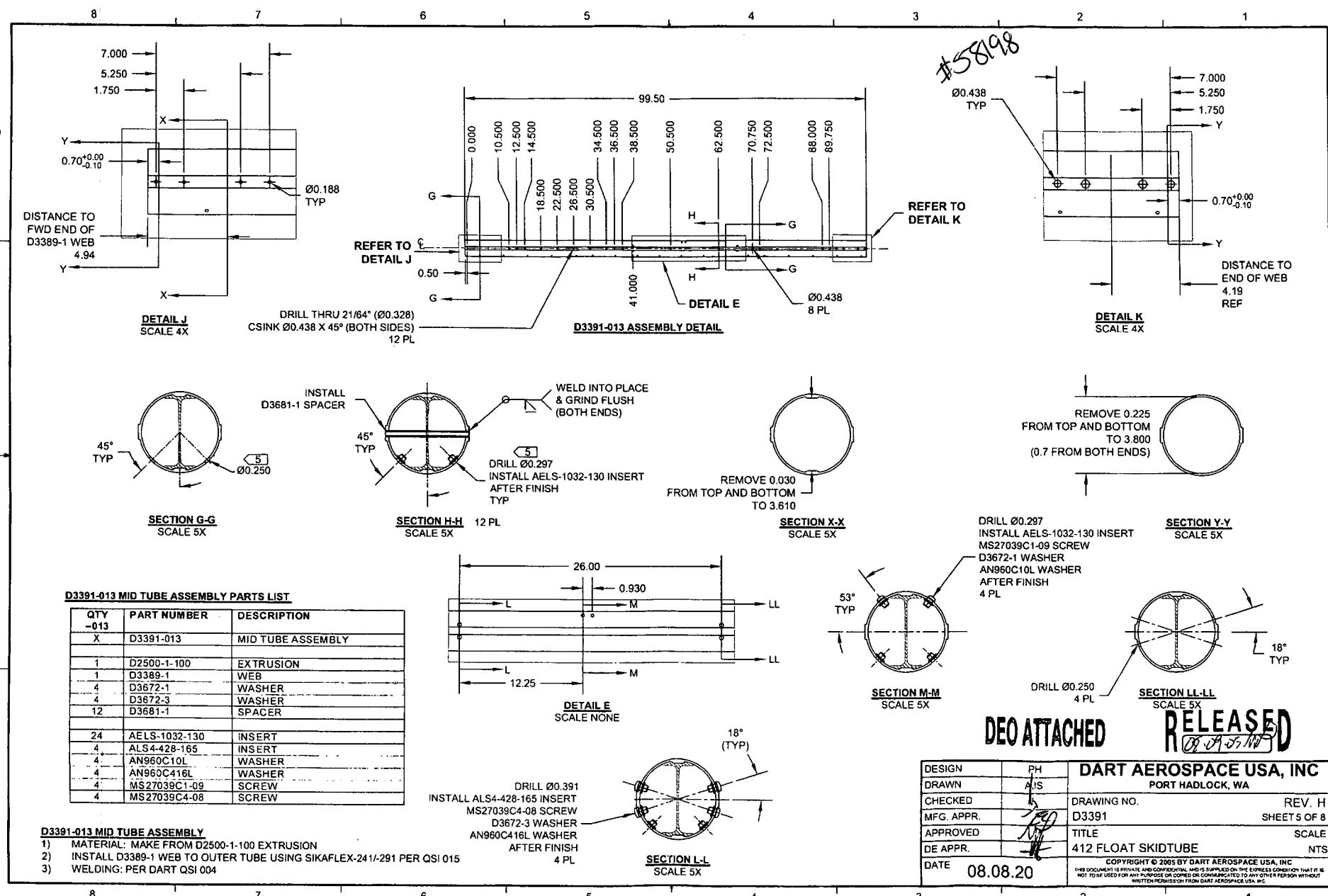
RELEASED
08-09-05 M

W/O:		WORK ORDER CHANGES					
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DEO ATTACHED

SCALE 5A
RELEASED

DART AEROSPACE USA, INC
PORT HADLOCK, WA

PONTIAC, IL

DRAWING NO. REV. F
D3391 SHEET 5 OF

D5551 SHEETS OF
TITLE **SCN**

NAME _____
412 FLOAT SKIRTURE _____

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WRITTEN PERMISSION FROM DART AEROSPACE USA, INC

2 1

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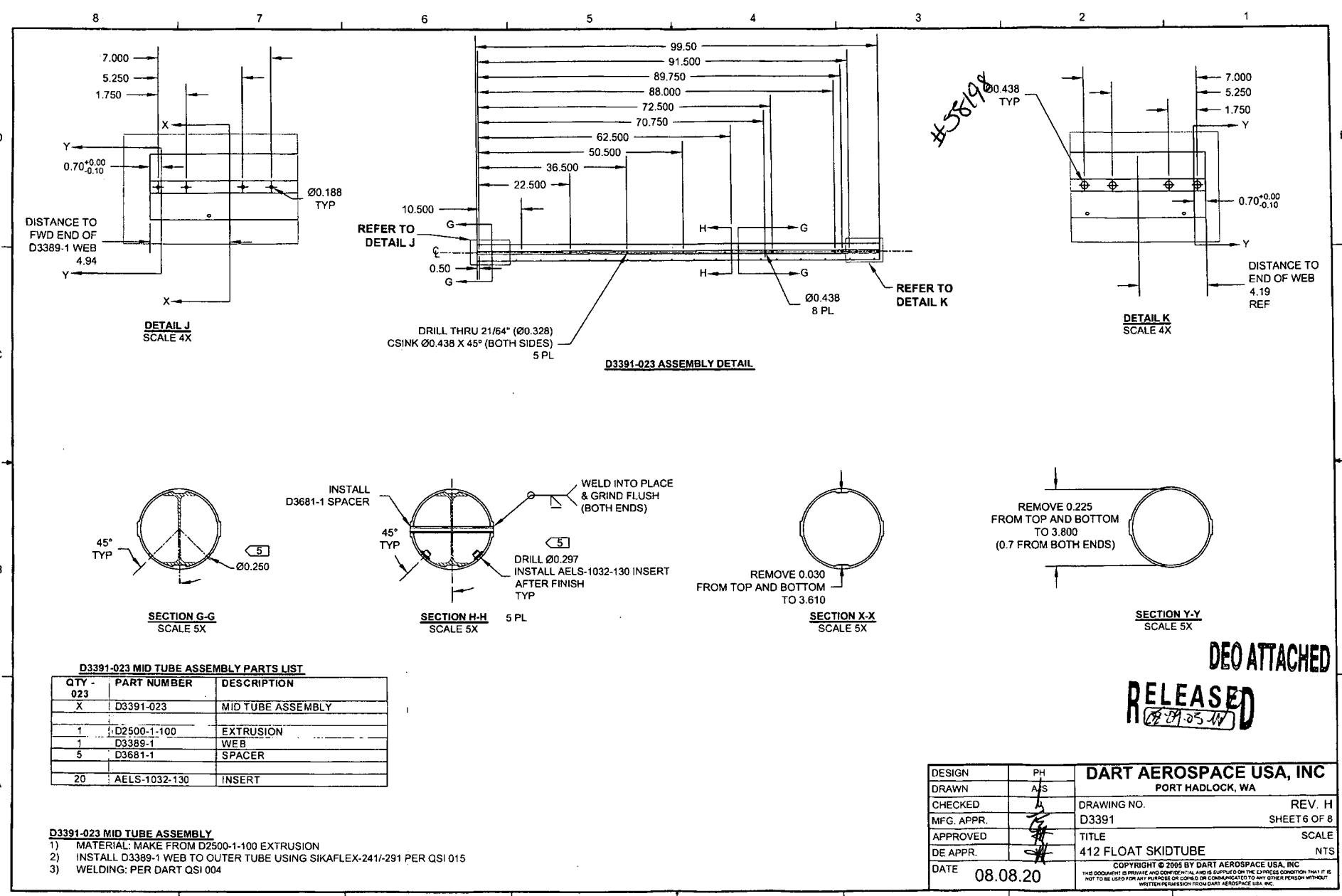
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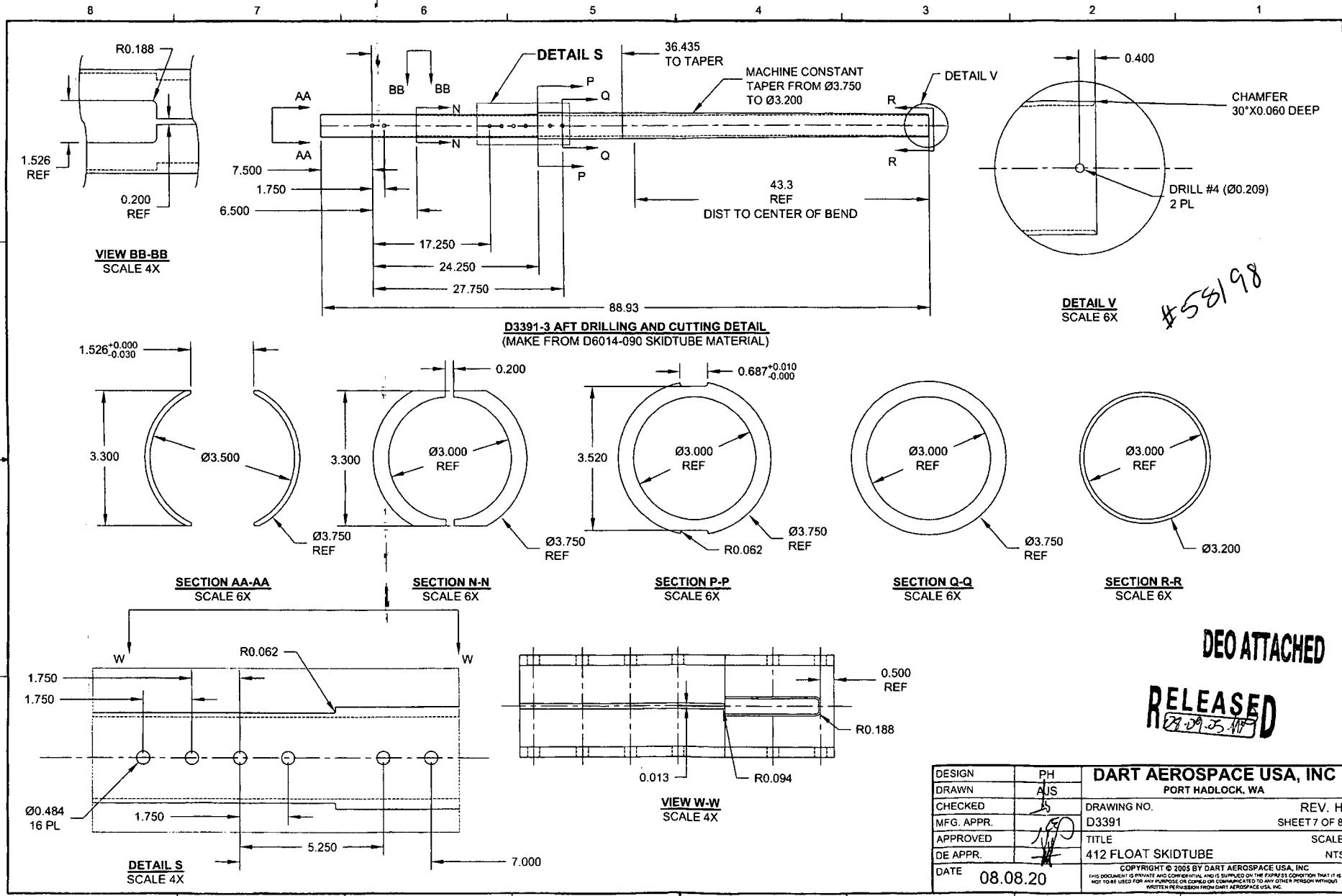
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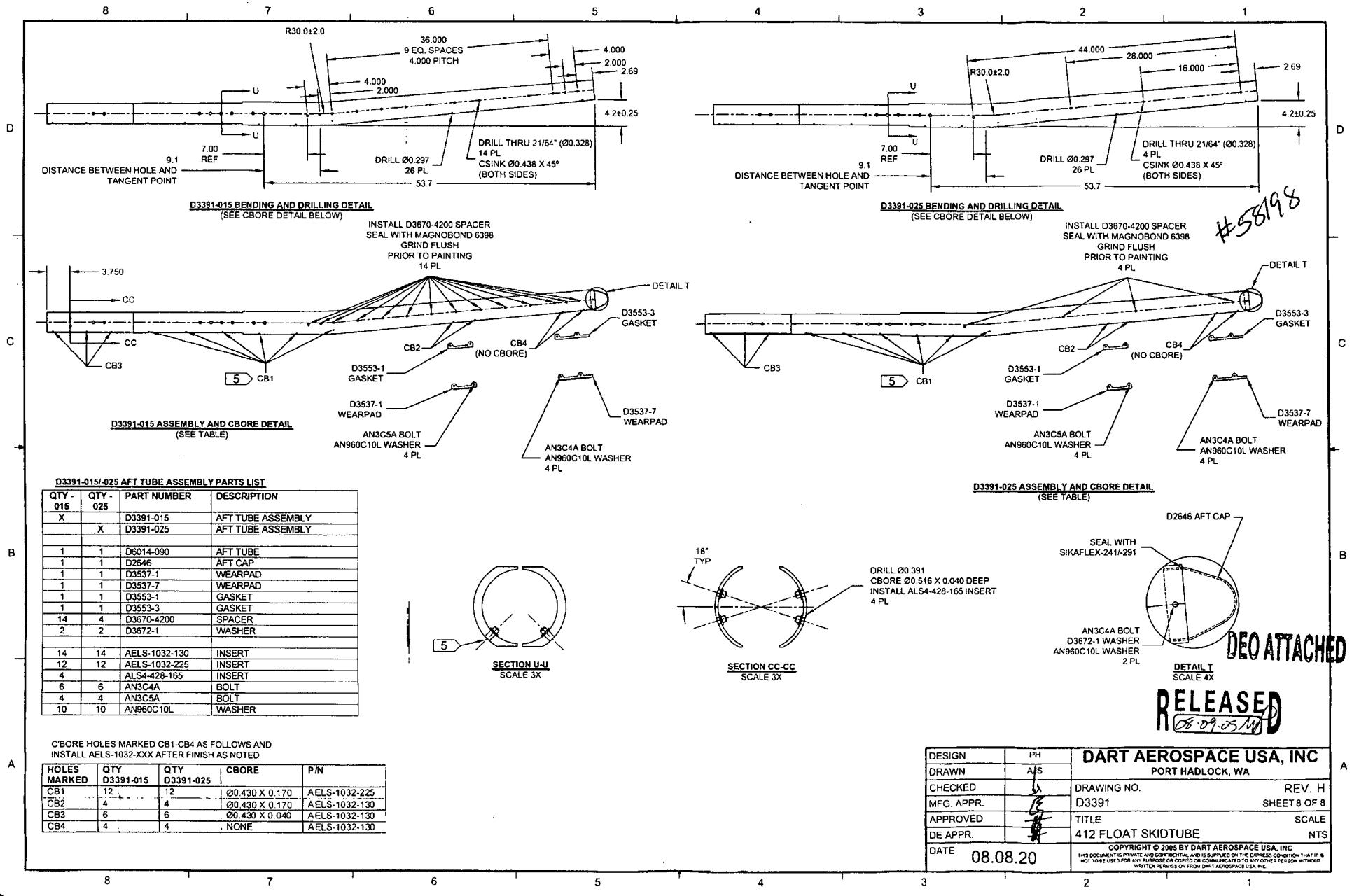


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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>✓</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>	DE APPR. <i>✓</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
2010-02-02

MP

#58198

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries